



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D135-751-011
Job Sheet 183650



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/21/18

Job Tracking No:

Due Date: 10/26/18

Created By: Jesse White

Type: Stock

Description: SIOP

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B
JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC
verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC
IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD
VERF:JLM

Ship Via:

Bill of Materials



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S119134



Part: D135-751-011

Job No: 183650

Serial No/Batch: S119134

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR01709SE 15/10/28, TC LoA RDIMS-9661680-v1 14/07

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		10/26/18	0.00	0.00	Start Up Skidtubes-1		BB
120	Skidtubes	1 pcs		10/26/18	0.00	0.80	Skidtubes-1		DAS 38
140	QC	1 pcs		10/26/18	0.00	0.00	QC5		38
150	HandFinish	1 pcs		10/26/18	0.00	0.33	HandFinish1		D.R. 18/10/25
160	QC	1 pcs		10/26/18	0.00	0.00	QC7-1		38
170	Skidtubes	1 pcs		10/26/18	0.00	1.00	Skidtubes-1		DD, BE DAS 38
180	QC	1 pcs		10/26/18	0.00	0.00	QC10		38
185	HandFinish	1 pcs		10/26/18	0.00	0.10	HandFinish6		D.R. 18/10/31
187	QC	1 pcs		10/26/18	0.00	0.00	QC7-1		38
190	Skidtubes	1 pcs		10/26/18	0.00	0.77	Skidtubes-1		DD DAS 38
200	QC	1 pcs		10/26/18	0.00	0.00	QC5		38
210	HandFinish	1 pcs		10/26/18	0.00	0.08	HandFinish2		D.R. 18/11/12
215	Outsource	1 pcs		10/26/18			ATE003-VC		5
220	SprayPaint	1 pcs		10/26/18	0.00	0.25	Spray Paint		Reed 18-11-13 NOV 15 2018
230	QC	1 pcs		10/26/18	0.00	0.00	QC14		68
260	HandFinish	1 pcs		10/26/18	0.00	0.74	HandFinish4		DAS 68
270	QC	1 pcs		10/26/18	0.00	0.00	QC5		DAS 68
280	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging1-1		6 NOV 19 2018
290	QC	1 pcs		10/26/18	0.00	0.00	QC4		6 NOV 19 2018
300	Packaging	1 pcs		10/26/18	0.00	0.00	Packaging3-1		6 NOV 20 2018
305	DC	1 pcs		10/26/18	0.00	0.00	DC		21 NOV 20 2018
310	QC21-FG	1 Ea		10/26/18	0.00	0.00	QC21		21 NOV 20 2018

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Locate DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill.****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868,Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892.Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : _____ end time: _____ 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: _____

260 - 1- Install Wearplate &Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: 5098/20

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

305 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

Sika flex M138943 Exp 19/03.

Job-BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	5117522
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5077412
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	8105604
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5092232
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5084958
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	5091974
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	5083326
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes	5066193-1
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5038208
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5112899
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5095223
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5095214
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5071664-3
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5045482
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	F126369
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	5107238
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5107030
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	F106110
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	5096801
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5082202
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5097982
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	5081645
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish	5089465
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	5106792
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5057659
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	5090630
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	5113705
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	5104354

5018138

M.U.6511

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	2	0
170-Skidtubes	D3504-1	2	12	0
	D3504-3	1	18	0
	D3504-5	2	38	0
	D3505-1	1	6	0
190-Skidtubes	D3506-1	4	48	0
	D3506-3	2	28	0
	MS20601-AD4W3	12	889	0
260-HandFinish	ALS4-1032-225	1	1,947	0
	ALS7-1032-130	38	1,267	0
	AN3C4A	31	2,249	0
	AN3C5A	2	1,934	0
	AN526C1032R10	2	110	0
	D2965	1	50	0
	D2965-3	1	10	0
	D3492-1	4	108	0
	D3492-3	4	153	0
	D3492-7	2	19	0
	D4918-047	1	7	0
	D4918-1	1	9	0
	D4918-3	1	8	0
	D4918-5	1	3	0
	NAS1149C0332R	33	5,199	0
	NAS1611-007	2	270	0
	NAS1611-010	4	433	0
	NAS1611-013	4	290	0
280-Packaging	AN3C4A	8	2,249	0
	D3512-041	2	5	0
	NAS1149C0332R	8	5,199	0

Part Specifications

Specifications could not be found.

Plex 9/21/18 4:02 PM dart.white.jesse



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041713**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041713
PO Date: 11/13/18
Due Date: 11/16/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	184225	D350-636-011	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
2	183650	D135-751-011	1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: _____ 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
3	182678	D350-636-016	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00
4	185412	D350-636-013	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041713**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	184892	D350-636-015	1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: _____ 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: _____	Firmed	-	11/16/18	1 pcs	0 pcs	1 pcs	\$325.00/pcs	\$325.00

Grand Total: \$1,625.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/14/18 9:19 AM dart.tsimiklis.chrisoula

5.0 PARTS LIST

Item	Qty -011	Qty -041	Qty -043	Qty -101	Part Number	Description
	X				D135-751-011	SKIDTUBE INSTALLATION
	1	X			D135-751-041	REPLACEMENT SKIDTUBE
			X		D135-751-043	WEARPLATE KIT
				X	D135-751-101	SKIDTUBE EXTENSION KIT
1		1			D3507-041	SKIDTUBE ASSEMBLY
2	4				**BRS8-96/48SZ-M8-W2	CLAMP
3	8				**LN9038-08032	SCREW
4		1			*D2965	CAP
5		1			*D2965-3	CAP
6		2			***AELS-1032-130	INSERT
7		2			***AELS-1032-225	INSERT
8		2			*AN3C5A	BOLT
9		2			*AN960C10L	WASHER
10		2			*AN526C1032-10	SCREW
20A		1	1		*D3508-1	WEARPLATE
20B		1	1		*D3558-1	GASKET
21A		1	1		*D3508-3	WEARPLATE
21B		1	1		*D3558-3	GASKET
22A		1	1		*D3508-5	WEARPLATE
22B		1	1		*D3558-5	GASKET
23A		1	1		*D3508-7	WEARPLATE
23B		1	1		*D3558-7	GASKET
24		38			*AELS-1032-130	INSERT
25	8	30	38		*AN3C4A	BOLT
26	8	30	38		*AN960C10L	WASHER
27	2		2		D3512-1	WEARPLATE
30		1			*AELS-1032-225	INSERT
31		1			*AN3C4A	BOLT
32		1			*AN960C10L	WASHER
40		4			*D3492-041	PLUG ASSEMBLY
41		4			***NAS1611-010	O-RING
42		2			*D3492-047	PLUG ASSEMBLY
43		2			***NAS1611-007	O-RING
44		4			*D3506-1	DOUBLER
45		8			*MS20601AD4W3	RIVET
46		2			*D3506-3	DOUBLER
47		4			*MS20601AD4W3	RIVET
48		4			*D3492-043	PLUG ASSEMBLY
49		4			***NAS1611-013	O-RING
50				1	D3510-041	INSERT ASSEMBLY
51				2	***AELS-1032-130	INSERT
52				6	***AELS-1032-225	INSERT
53				2	***ALS4-428-165	INSERT
54				2	AN4C7A	BOLT
55				2	AN960C416L	WASHER
56				2	AN3C4A	BOLT
57				8	AN3C7A	BOLT
58				10	AN960C10L	WASHER

* PART IS INCLUDED WITH D3507-041 SKIDTUBE ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER, LISTED AS REFERENCE ONLY

*** DENOTES PART IS INCLUDED WITH ASSEMBLY ABOVE

• COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. •

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: C

Date: 07.09.20

REFERENCE ONLY

PARTS LIST:

THE PARTS LISTS IN SECTION 32.9 OF ICA-D135-751 (PAGE 35) AND SECTION 5.0 OF IIN-D135-751 (PAGE 11) ARE AMENDED AS FOLLOWS FOR D135-751-011 @ CHG 002 AND LATER. **REFERENCE ONLY**

32.9 PARTS LIST (ICA-D135-751)**5.0 PARTS LIST (IIN-D135-751)**

Item	QTY -011	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X			D135-751-011	SKIDTUBE INSTALLATION
	1	X		D135-751-041	REPLACEMENT SKIDTUBE
			X	D135-751-043	WEARPLATE KIT

IS:

20A	1		1	D4918-1	WEARPLATE (REPLACES D3508-1)
21A	1		1	D4918-3	WEARPLATE (REPLACES D3508-3)
22A	1		1	D4918-5	WEARPLATE (REPLACES D3508-5)
23A	1		1	D4918-047	WEARPLATE (REPLACES D3508-7)
27	2		2	D3512-041	WEARPLATE (REPLACES D3512-1)

WAS:

20A	1		1	D3508-1	WEARPLATE
20B	1		1	D3558-1	GASKET
21A	1		1	D3508-3	WEARPLATE
21B	1		1	D3558-3	GASKET
22A	1		1	D3508-5	WEARPLATE
22B	1		1	D3558-5	GASKET
23A	1		1	D3508-7	WEARPLATE
23B	1		1	D3558-7	GASKET
27	2		2	D3512-1	WEARPLATE

THE PARTS LIST FOR THE DSI 9661-011 KIT IS AS FOLLOWS:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI 9661-011	WEARPLATE UPGRADE KIT
1	D4918-047	WEARPLATE
2	D3512-041	WEARPLATE

REFERENCE ONLY

DESIGN	DW	DART AEROSPACE USA, INC KENT, WA	
DRAWN	DW		
CHECKED	<i>GP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>N/A</i>	DSI 9661	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		REVISED WEARPLATE KIT	NTS
DATE	13.08.21	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

REFERENCE ONLY

REFERENCE ONLY